

Work Order ID 78136

78136

Page 1

December-29-11 10:34:24 AM

Item ID: D2661-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 29/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/28 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA

DWG REV: E

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78136***78136***

Page 2

December-29-11 10:34:24 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH Fwd Aft Out 206
Start Date: 29/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	12/01/28		10	4		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	Rq	12-1-30		10	4		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	BL 12-2-2		

W/O:		WORK ORDER CHANGES					
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Page 3

December-29-11 10:34:24 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 29/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:20 FINISH TIME: 3:50	0.00 0.00							WXC M 12/02/02
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							10 BL 1222
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 430 Memo	0.00 0.00							C14/2/3 (10)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 29/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten notes: *U.C.J. 12/02/03* (with signature) and *12-02-3* (with circled 'W')

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-29-11 10:34:27 AM

Page 1

Work Order ID: 78136

78136

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	92.0000	1	10			
D6101-003									**				
Saddle Billet, 7075													

Location	Loc Qty	Loc Code
MAT040	16	
73775	2	
73780	7	
MAT042	-7	
MAT044	83	
73769	1	
76837	82	
78599		

10. FK 12/01/27

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 78136
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				5 By	Date
				1	2	3	4		
A	0.100	0.140		0.133	0.133	0.133	0.133	0.133	
B	0.100	0.140		0.126	0.126	0.126	0.126	0.126	
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.255	0.255	0.255	0.255	0.255	
F	1.313	1.343		1.327	1.327	1.325	1.325	1.325	
G	0.210	0.230		0.228	0.228	0.227	0.227	0.227	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.575	1.574	1.574	1.574	1.575	
K	0.235	0.240		0.236	0.236	0.236	0.236	0.236	
L	0.100	0.120		0.109	0.109	0.109	0.109	0.109	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		0.512	0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.314	0.314	0.314	0.314	0.314	
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.260	0.260	0.260	0.260	0.260	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.499	0.500	0.500	0.500	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: H.A.
Date: 12/01/28

Audited by: i2c
Date: 12.1.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 78136
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				16	17	18	19	10 By	
A	0.100	0.140		0.133	0.133	0.133	0.133	0.133	
B	0.100	0.140		0.126	0.126	0.126	0.126	0.126	
C	1.125	1.145		1.1355	1.135	1.135	1.135	1.135	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.254	0.254	0.254	0.254	0.254	
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325	
G	0.210	0.230		0.227	0.227	0.227	0.227	0.227	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.5745	1.575	1.574	1.575	1.574	
K	0.235	0.240		0.236	0.236	0.236	0.235	0.237	
L	0.100	0.120		0.109	0.109	0.109	0.108	0.110	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		0.512	0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.314	0.314	0.314	0.314	0.314	
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.367	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.260	0.260	0.260	0.260	0.260	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.500	0.500	0.500	0.500	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: B.A
Date: 12/01/28

Audited by: i27
Date: 12.1.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
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G	11.11.07	Dimensions C and F revised	KJ	

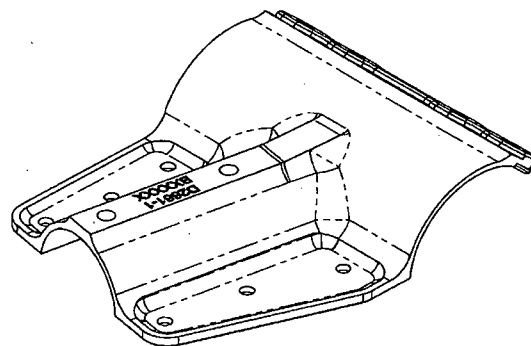
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

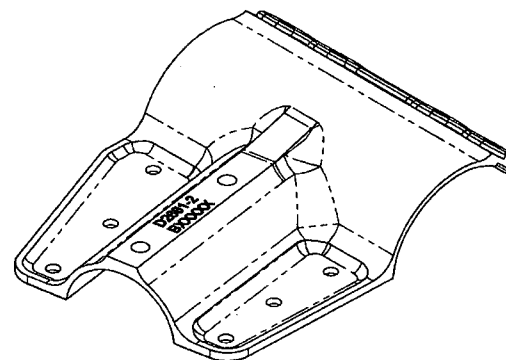
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 70136 MLJ
11/12/29

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	g	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	g		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	g	D2661	SHEET 1 OF 5
APPROVED	g	TITLE	SCALE
DE APPR.	g	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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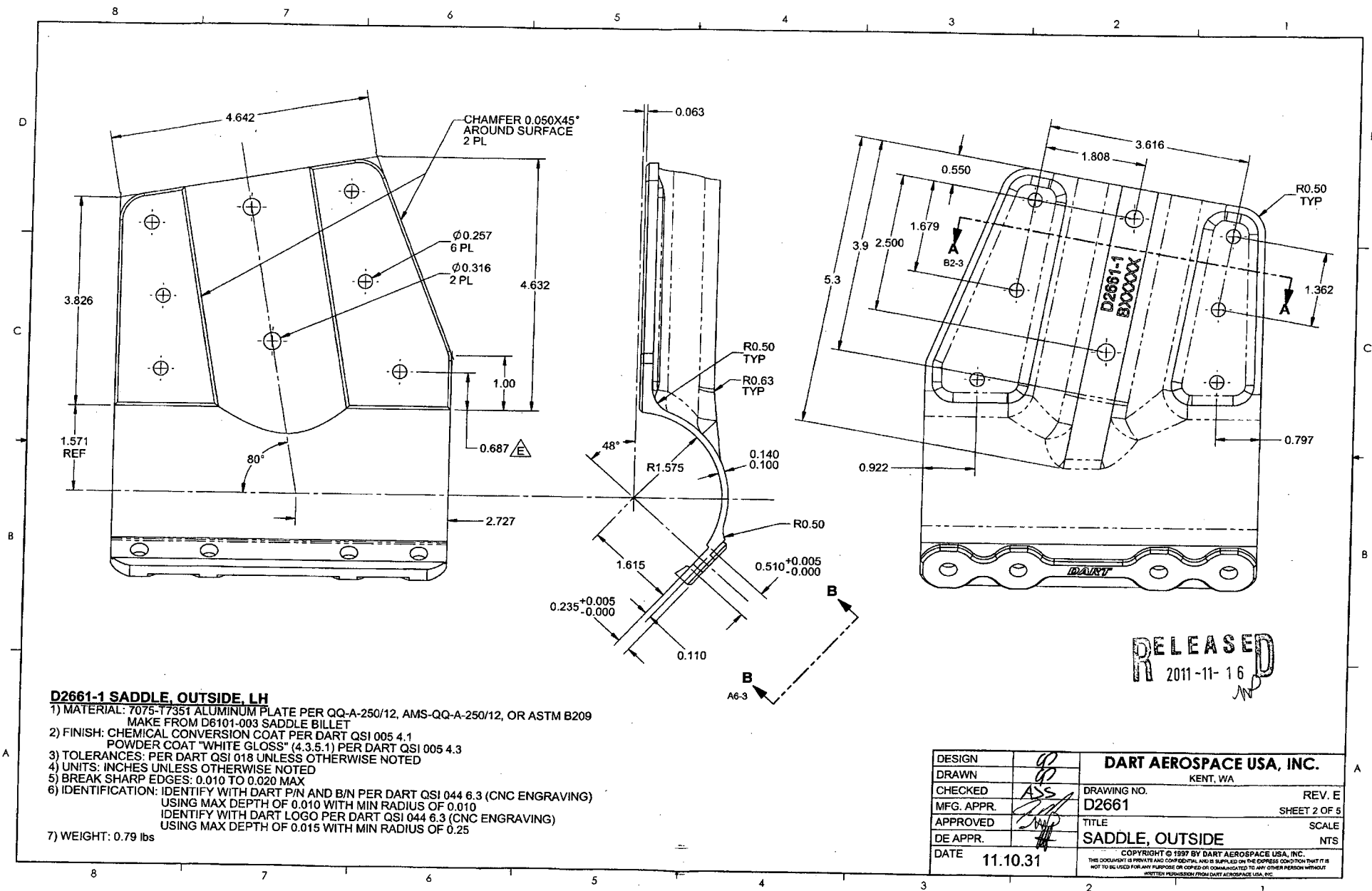
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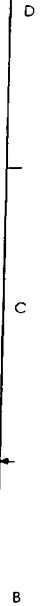
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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A horizontal number line with tick marks labeled 1 through 8 from right to left. The line is divided into segments by these tick marks.



A4-2



C3-2

NT

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

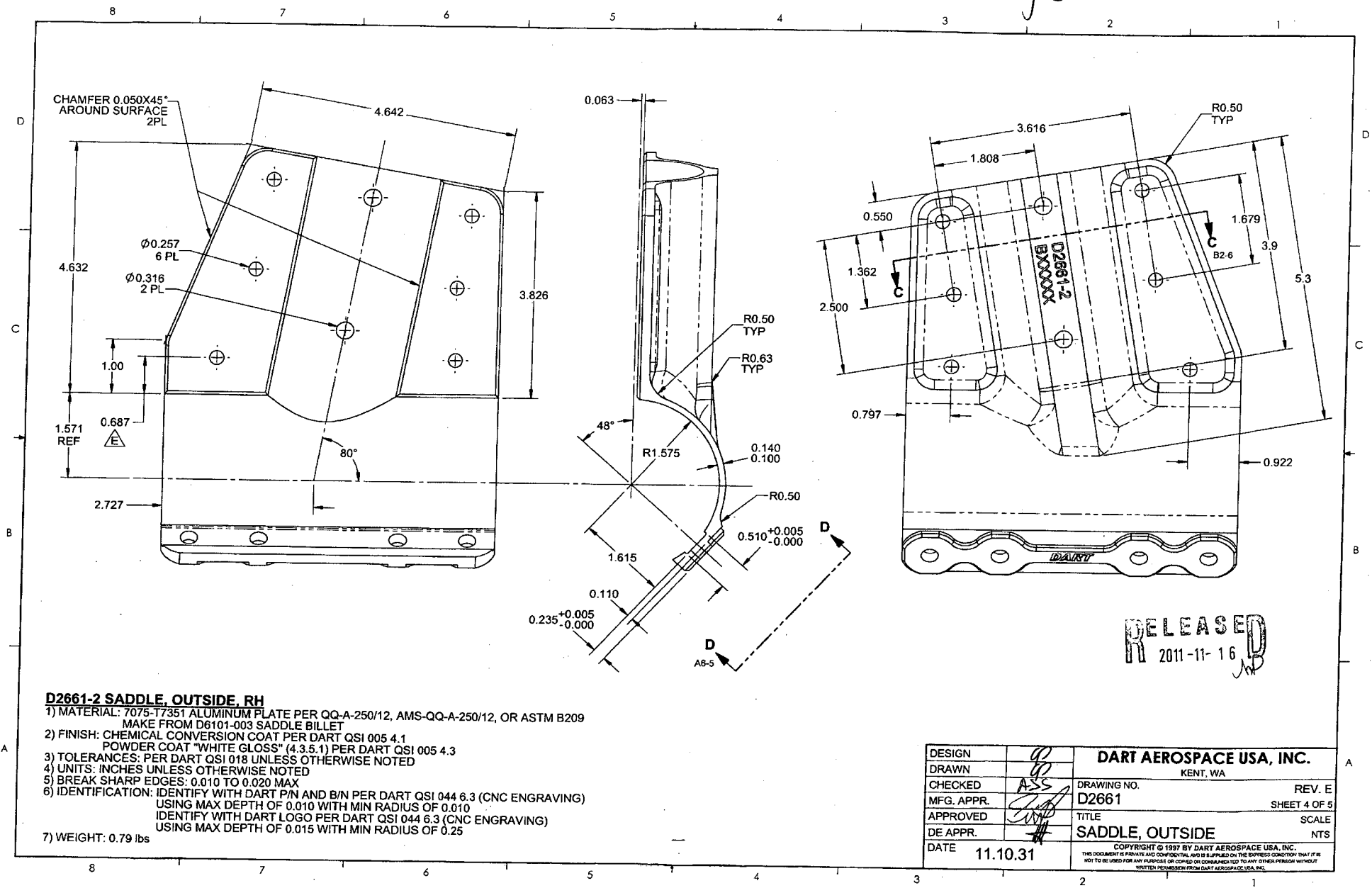
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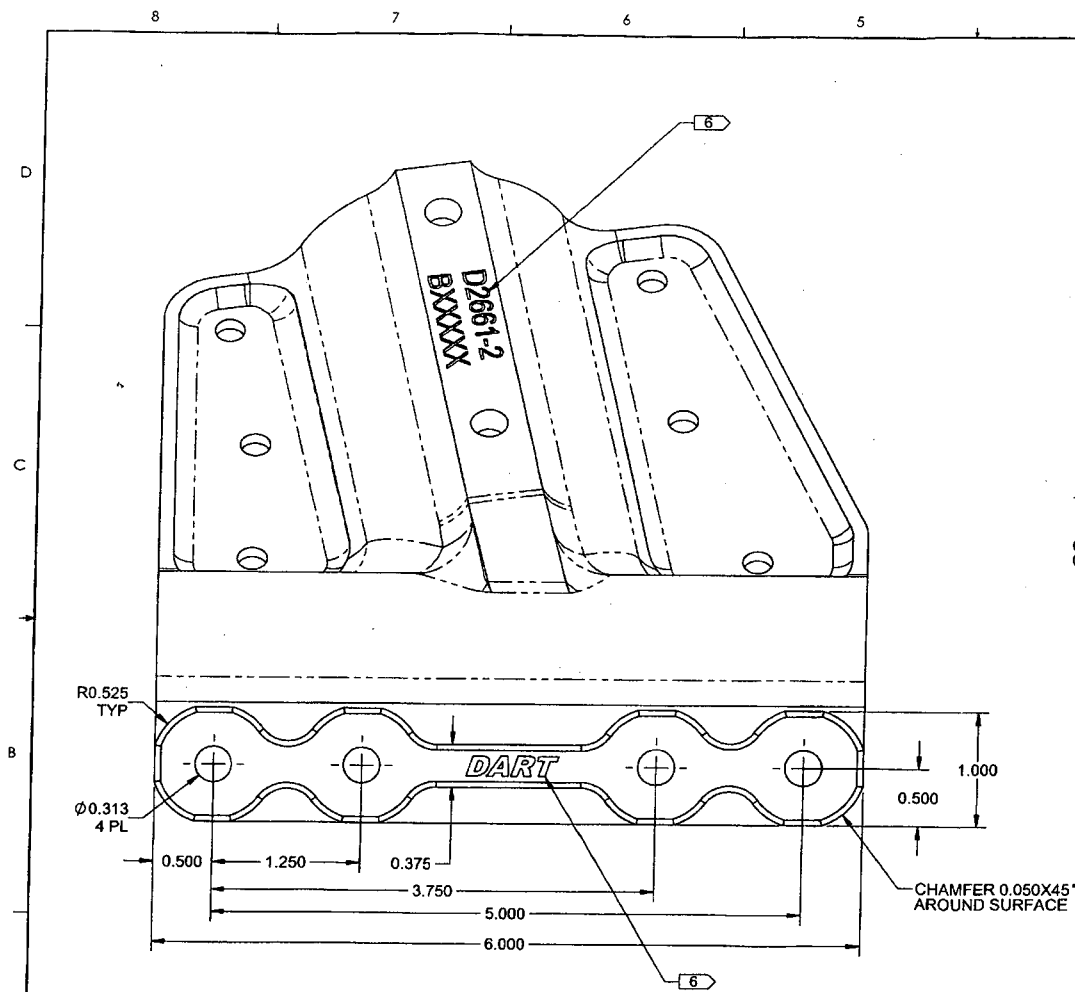
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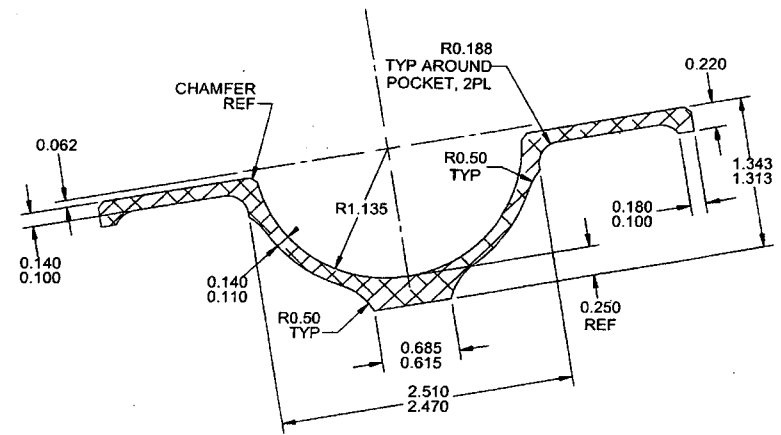
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NOTE: Date & initial all entries

78136



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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